

Split  
Work Order ID 102293-2

May-27-13 2:25:11 PM

\*102293\*

Page 1

Item ID: D3197-041

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Bar Assembly

Start Date: 5/27/13 Start Qty: 6.00

Required Date: 5/31/13 Req'd Qty: 6.00

Reference:

Approvals: Process Plan: MJS

Date: 13-05-27

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3197

Rev B

100

0.00

\*100\*

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 29.125" long

SA 13-5-29

6

110

0.00

\*110\*

HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

1-Face ends to length per dwg D31972-Machine D3197-1 as per Folio FA340 and Dwg D31973-Deburr

85 13 05 30 (x4)

120

QC2- Inspect parts off machine FAI/FAIB

0.00

\*120\*

QC

Memo

0.00

Quality Control

13 05 30 (x4)

# Work Order ID 102293

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\*102293\*

Page 2

Item ID: D3197-041

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Bar Assembly

Start Date: 5/27/13

Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 5/31/13

Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

\*130\*

Lathe Conv

CONVENTIONAL LATHE

Memo

Chamfer as per Dwg D3197

0.00

0.00

13-5-29

4

140

\*140\*

QC

QC8- Inspect parts - second check

Memo

0.00

0.00

13/05/31

4

Quality Control

150

\*150\*

HandFinish

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

4 13-6-3

Hand Finishing

# Work Order ID 102293

\*102293\*

Page 3

Item ID: D3197-041

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Bar Assembly

Start Date: 5/27/13 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 5/31/13 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

160

Grey Sandtex(Ref:4.3.5.6) per QS1005 4.3

0.00

\*160\*

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

320-1

170

QC3- Inspect Part Finish

0.00

\*170\*

QC

Memo

0.00

Quality Control

180

Small Fab

0.00

\*180\*

Small Fab

Memo

0.00

Small Fab

Assemble D3197-041 as per Dwg D3197

4X4 m/f 13/06/03

4 φ B-G-3

2 FF 13-06-04



# Work Order ID 102293

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\*102293\*

Page 4

Item ID: D3197-041

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Bar Assembly

Start Date: 5/27/13 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 5/31/13 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

\*190\*

QC

Memo

0.00

Quality Control

0.27  
13 6 4

2

200

Identify as per dwg & Stock Location: 81259 0.00

0.00

\*200\*

Packaging

Memo

0.00

Packaging

2X

13-6-4

210

QC21- Final Inspection - Work Order Release 0.00

0.00

\*210\*

QC

Memo

0.00

Quality Control

MLJ 13-06-05

PL 13-06-4

# Picklist Print

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Page 1

Work Order ID: 102293  
Parent Item: D3197-041  
Parent Item Name: Bar Assembly

Start Date: 5/27/13  
Start Qty: 6.00

Required Date: 5/31/13  
Required Qty: 6.00

Comments: IPP Rev: A New Issue 05-11-08 JLM  
IPP Rev: B As per Rev B 06-03-10 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS27039-1-24 Screw		Purchased	No			100	Each	50.0000	2	12			FF 13-06-03
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		50							
				121912		50							
AN960JD10 Washer	NAS1149D0363J	Purchased	No	124392		180	Each	0.0000	6	36			FF 13-06-03
D2690-5 Lanyard Assembly		Manufactured	No			180	Each	9.0000	2	12			FF 13-06-03
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST014		9		B102195		3			
				100722		8				4			
				91937		1				1			
D3242-1 Tag		Manufactured	No			180	Each	12.0000	2	12			FF 13-06-03
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		12				9			
				100723		12							
D3489-3-200 PIP PIN		Manufactured	No			180	Each	17.0000	2	12			FF 13-06-03
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		17				3			
				100724		12				5			
				96109		5							

# Picklist Print

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Work Order ID: 102293  
 Parent Item: D3197-041  
 Parent Item Name: Bar Assembly

Start Date: 5/27/13

Required Date: 5/31/13

Start Qty: 6.00

Required Qty: 6.00

M7075T73R1.000  
 7075-T73 Rd Bar 1.00

Purchased No

180 f 65.3200 2.42 18.15

## Location

## Loc Qty

## Loc Code

MAT012  
 120503  
 122386  
 125586

65.32  
 11.05  
 6.27  
 48

14.625 Lt

SA-13-5-29

MS21042L3  
 Nut

Purchased No

180 Each 3,231.0000 2 12

FF 13-06-03

## Location

## Loc Qty

## Loc Code

FP001  
 122141  
 GA  
 122452  
 ST314  
 117885  
 119017  
 119075  
 123265  
 ST506  
 123900  
 124291

3  
 3  
 18  
 18  
 268  
 32  
 55  
 138  
 43  
 2942  
 954  
 1988

8

May-27-13 2:25:11 PM

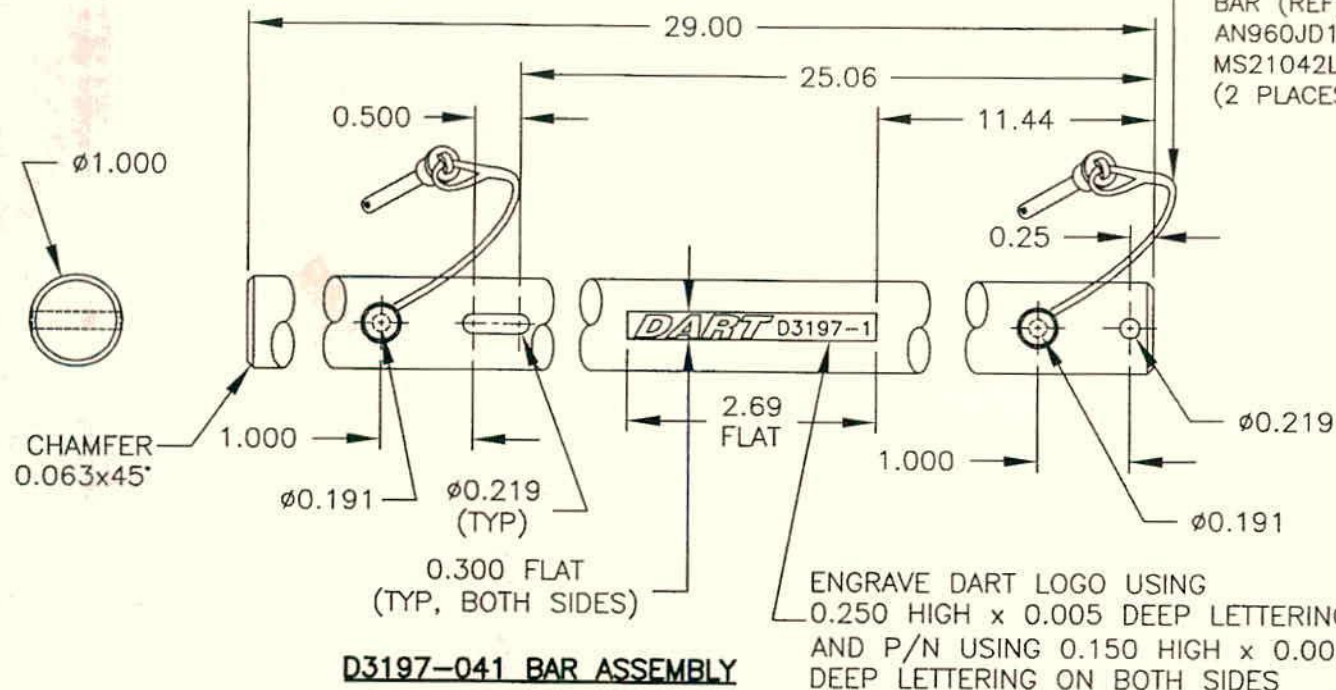
Shop Packet Print

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D3489-3-200 PIP PIN (1)  
D3242-1 TAG (1)  
MS27039-1-24 BOLT (1)  
AN960JD10 WASHER (1)  
D2690-5 LANYARD (1)  
AN960JD10 WASHER (1)  
BAR (REF)  
AN960JD10 WASHER (1)  
MS21042L3 NUT (1)  
(2 PLACES)



D3197-1 BAR

- 1) MATERIAL: 7075-T73 ROUND BAR (QQ-A-200/11 or QQ-A-225/9)  $\phi$ 1.000 O.D.  
(REF DART SPEC. M7075T73R1.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) FOR TOOLING, IT IS ACCEPTABLE TO HAVE A 0.06 DEEP x 60° CENTER MARK AT EITHER  
END OF THE BAR

102293 MVS  
13-05-27

CHECKED		APPROVED	DRAWING NO.	REV. B
CP		CP	D3197	
DATE			TITLE	SHEET 1 OF 1
06.01.10			BAR	SCALE 1:1
A	03.07.01		NEW ISSUE	
B	06.01.10		CHG PIP PIN; ADD D3242-1 TAG	

DART

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